

Date: Monday, 18/08/2008 3:46:37 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ADJUSTABLE ATTACHMENT ARM ASSY
Job Number	: 41383		
Estimate Number	: 13479		
P.O. Number	:	Part Number	: PB674300159
This Issue	: 18/08/2008 S.O. No. :	Drawing Number	: B6743001 P.14
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 40693	Material	:
Written By	:	Due Date	: 18/09/2008
Checked & Approved By	: <u>DD 08.8.18</u>	Qty:	3 Um: Each
Comment	: Est Rev:A 08-07-18 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001113	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)
 Square Tubing
 batch: B 41477



SP. 08.10.20 (3X)

2.0	PB6743001119	End Cap Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)
 End Cap Clevis
 batch: B 23991



SP 08.10.20 (3X)

3.0	PB6743001117	Hook Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)
 Hook Plate
 batch: B 41865



SP 08.10.20 (3X)

4.0	PB6743001115	Tube End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)
 Tube End Plate
 batch: B 24087



SP 08.10.20 (3X)

5.0	PB6743001271	Doubler
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)
 Doubler
 batch: B 40058 = 4X



B 41498 = 2
 SP 08.10.20 (3X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M6061T6T1750W065

6061T6 RDTUBE 1.750 X 0.65W



Comment: Qty.: 0.1575 f(s)/Unit Total: 1.2600 f(s)

6061T6 RDTUBE 1.750 X 0.65W

batch: ~~B 41477~~ M18489

SP 08.10.20. (3X)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1- to make -105 take M6061T6 tube and fabricate to fit contour of cut SP

2- Weld -105 to -113 as per dwg and grind weld flush SP

3- weld 119, -117 and -115 to -113 as per dwg PB67-43001 SP

4- pick two -271 and weld one on each side of tubing but only one need to be trim to fit on -113 as per dwg

PB67-43001 SP

SP 08.10.20. (3X)

8.0

QC9

VISUAL WELDING INSPECTION



Cpl 08-10-22 BE (X3)

Comment: VISUAL WELDING INSPECTION

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/22 (X3)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HJ

08-10-22 (X3)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

11:15am

OVEN TEMPERATURE:

320°F

FINISH TIME:

11:45am

HJ

08-10-22 (X3)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. H

08/10/22 (3X)

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	PB6743001267	PB67-43001-267
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

PB67-43001-267

batch: 90095 x 3, 41497

Cpl 08.10.22

14.0	PB6743001121	Square Sleeve
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Square Sleeve

batch: B40612 x 2, 41866 x 2

Cpl 08.10.22

15.0	BSP43	RIVET
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 48.0000 Each(s)

RIVET

batch: m109119

Cpl 08.10.22

16.0	MS17984C413	PIN, QUICK RELEASE
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

PIN, QUICK RELEASE

batch: m108986 x 2, m108826 x 6

* sent to Ireland

Cpl 08.10.22

17.0	30345T21	LANYARD
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

LANYARD

batch: m107828

Cpl 08.10.22

18.0	MS27039122	SCREW
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

SCREW

batch: m18057

Cpl 08.10.22

19.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

batch: m109031

Cpl 08.10.22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Machine Or Operation:

Description :

20.0

NAS1149F0332P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

batch: m18057

P1608-10-22

21.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- take -267 and transfer drill holes in -113 as per dwg PB67-43001

2- deburr and rivet -267 to -113 as per dwg

3- assemble rest of parts as per dwg PB67-43001

SAP 08/10/23

(x3)

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/23 (x2)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CARL

welding

S 08/10/23 (x3)

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/23

Job Completion



MF 08-10-23

W/O:		WORK ORDER CHANGES					
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